Work Order ID June-24-13 1:55:02 PM		· _	*10.3	3409*			· ·			Page 1	
Item ID: D2933-7 Revision ID:	2	ţ	Accept	*N900	<u>040</u>	100)* 's	etup Stai	*N	S1*	
Item Name: 206 Sado	lle Right		3					Sto	*N	S2*	
Start Date: 6/24/13	Start Qty: 6.00	*6*		Cust Item I	D.					• • •	
Required Date: 7/12/13	Req'd Qty: 6.00		**	Cust mem i	D.						•
Reference:	neq a Qiy. o.oo	*6*	·	Customer.	-						
Approvals: Proces	s Plan:MUS	Date: 13 06 23	- Tooling:		ate:		- R	tun Star	1/1	R1*	
		•		D	ate:			Sto	*N	R2*	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr				· · · · · · ·						
D2933	Rev C										
100			0.00								
100	HAAS CNC VERTICA	L MACHINING #1	•		SJ13-08.	-20	6	10			
HAAS I	Memo		0.00		. •			- -		4.	
HAAS CNC vertical machine	number are inspect as p	art number and batch number programmed correctly.2-Mater per dwg D2933 & attached D d visually inspect as per	achine Step No 1 of Fol	io and visually							
110			0.00								
110	CONVENTIONAL MI	LLING MACHINE		,	1,3-03-1		(D			
Mill Conv	Memo		0.00	1	13-08-1	Z ⁰			· -		
Conventional Milling Machine	e Muchine K	eyway and inspect per attach	ed dimension sheet								
120	QC1- Inspect dimensio	ns to dimension sheet	0.00				,	,			
120			0.00	01.	3-08-20		ي			- .	
QC Quality Control	Мето		V.00	Store	2-00-00						

DQA:		_ Date:										TOAC.
QA Closed:		Date:			WORK ORDER NON	-C(ONFO	RMANCE / UPDATE	14/	ork Order up	adata anlu - [AEROSPACE
LA Closed:		Date.		1					VV	ork Order up	date only	<u> </u>
Work Orde	er:				DISPOSITION			AGAINST	T DE	PARTMENT	/PROCESS	
			•		Rework]		Skid-tube Crosstube	•		Water Jet	Engineering
Part N	lo.				Scrap	1		Machining Small Fab	_	Pro	d. Eng. Coor.	Quality
					Use-as-is		Therr	noforming Finishing	3	Rec/Sto	re/Packaging	Other
NCR N	10			_	Suspected Unapproved]		Large Fab Composite]	Supplier	
Root				Descr	iption of work order update		Initial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Design	-					1						
Doc/Data			1									
Equip/Tooling												
Handling/Pre												
Material												
Operator												
Offset/Setup		1										
Process] !									
Supplier												
Training												
Transport												
Unapproved		.										
						FAI	ULT CA	TEGORY				
Landir	ng Gear			_	General	_				-		_
]	Bendin	3			Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
	Centre	Not Concer	ntric		BOM/Route	L	Grain		L	Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect	<u> </u>	Hardwa	are		Part Incorred	ct	Temperature/Cure
ļ	Crimp/l	(ink/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld
	Cuffs			Ш	Contamination		₹	tions Incomplete/Unclear	_	Part Moved		Wrong Stock Pulled
	Crushin	g		-	Countersink		Misalig	gned/off center		Positioned V	Vrong	
	Heat Tr				Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
	Inspect	on Strip in	Tube	-	Drawing		Misrea	d				
	Marks/	Chatter		Ш	Drill Holes		Off-set					
	Turning	Sequence			Finish		Out of	Calibration				
J	Wave/T	wist in Tub	ne .		Fit/Function		Out of	Sentience				

Work Orde					*1	N 3,	409*	•							Page	2
Revision ID:	D2933-7				Accept		*N90	າດເ	<u>140</u>	100) * s	Setup St	art op	*N:	S1*	
	6/24/13	Start Qty: (Req'd Qty: (*6* *6*	,		Cust It		:					1 (1)	. 12	
Approvals:	Proces	s Plan:	Date:		Tooling:			Date	e:		F		art	*N	R1*	
	QC:_		Date:		SPC (Y/N)) : .	,	Date	e:			St	ор	*N	R2*	
Sequence ID/ Work Center II	<u> </u>	Operation Description OC8- Inspect pa	rts - second check		Set Up/ Run Ho		Tool 1	ID	Tool #	Plan Code	Accept Qty	Reject Qty		eject umber	Insp. Stamp	
130 QC Quality Control		Mer			0.00	O A A	13/08/2	ZZ			6	<u>Ø</u>				_
*140		Chemical Conve	rsion Coat per QS	005 4.1	0.00						6	72	BH	380	77	
HandFinish Hand Finishing		Mer	по		0.00						<u> </u>		<u>-</u> 7 <u>u</u>			_
150		White Gloss(Ref	4.3.5.1) per QS10	05 4.3-Alum	0.00						1.,			<i>.</i>	, 1	
150 Powdercoat		Mer	no	011	ري ک _{اره} ک					(bx y	8_!N,	2/	13/	8/2	4
Powder Coating	.6	STA	IRT TIME:FINISH T	IME:	_OVEN TEMPER								,	,	, ,	

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DQA:		Date:										TAART
QA Closed:		Date:			WORK ORDER NON	-C(ONFO	RMANCE / UPDATE	W	ork Order up	odate only	AEROSPACE
					DISPOSITION			AGAIN		EPARTMENT,		- <u>- , </u>
Work Orde	er:					,				, ¬	_	.
Part N	ło.				Rework Scrap			Skid-tube Crosstu Machining Small F	_	Pro	Water Jet d. Eng. Coor.	Engineering Quality
					Use-as-is	1 1	Therr	noforming Finishi	ng		re/Packaging	Other
NCR N	Vo				Suspected Unapproved]		Large Fab Compos	ite]	Supplier	
Root	-			Desci	ription of work order update		Initial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design					· · · · · · · · · · · · · · · · · · ·	Г						
Doc/Data		ļ										
Equip/Tooling						-						
Handling/Pre		ĺ										
Material												
Operator				*	•							
Offset/Setup]	ن. -					
Process		1				ł						
Supplier			1									
Training			!								·	
Transport												
Unapproved												
						FAI	ULT CA	TEGORY				
Landi	ng Gear				General		_			-		<u> </u>
	Bendin	g			Bend		Folio/F	Program	L	Outside Dim	ensions	Pressure/Forced
	Centre	Not Conce	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorre	ct	Temperature/Cure
	Crimp/	Kink/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		Instruct	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
	Crushir	ng			Countersink		Misalig	ned/off center		Positioned V	Vrong	<u>_</u>
	Heat Ti	eat			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
	Inspect	ion Strip in	Tube		Drawing		Misread	b				
	Marks/	Chatter			Drill Holes		Off-set					
=	Turnin	g Sequence	<u> </u>		Finish		Out of	Calibration				
	Wave/	Twist in Tul	be		Fit/Function		Out of	Sequence				

Work Ord		03409		*103	3409*							Page 3	;
tem ID: Revision ID: tem Name:	D2933-2 206 Saddle l	Right		Accept	*N900	<u>ი</u> 4ი	100)* s	Setup	Start Stop	*N:	S1* S2*	
Start Date: Required Date Reference:	6/24/13 : 7/12/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:							
Approvals:		lan:				ate:		J	Run	Start Stop	1/11	R1* R2*	
Sequence ID/ Work Center I 60 *160 CC Quality Control	D	Operation Description QC3- Inspect Part Finish Memo		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp	13-08
170 *170* Packaging Packaging		Identify as per dwg & Sto Memo	ock Location:STY	37 0.00 0.00				lox				3.5	- <i>)</i> 9
*180 *180* QC Quality Control		QC21- Final Inspection - Memo	Work Order Release	0.00						<u>17</u>	18/2	129	_
										K	[B-0")	

	_ Date:				-		DA 4 4 4 5 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1				TAART
	Date:			WORK ORDER NON-	-60	ONFO	RIMANCE / UPI		ork Order up	odate only	AEROSPACE
<i>.</i>				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
	· · · <u>-</u>		_	Rework]		Skid-tube	Crosstube]	Water Jet	Engineering
o				Scrap			~ — ·	Small Fab	7	-	Quality
o				Use-as-is Suspected Unapproved	}	Thern	- ⊢	- - - -	Rec/Sto	re/Packaging Supplier	Other
	T		Desci	ription of work order update		nitial	Actio	on	Sign &		
Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	tion	Date	Verification	QC Inspector
				i	1						
j											
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					FAI	ULT CA1	TEGORY				
g Gear				General							
Bending				Bend		Folio/P	rogram		Outside Dim	ensions	Pressure/Forced
Centre N	lot Concei	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
Cracks				Broken/Damage/Defect	Г	Hardwa	re		Part Incorred	ct	Temperature/Cure
Crimp/Ki	ink/Ripple	/Wave		Burrs	Г	Inspecti	ion Incomplete/Unq	ualified	Part Lost/Mi	ssing	Weld
Cuffs				Contamination		Instruct	ions Incomplete/Un	clear	Part Moved	<u> </u>	Wrong Stock Pulled
Crushing	<u> </u>			Countersink		4		—	Positioned V	ت Vrong	
				Cut Too Short							Other
Inspection	on Strip in	Tube		'		•		_	-	~ <u>L</u>	
				Drill Holes		Off-set			-		,
⊣				Finish		1	Calibration				
─				Fit/Function		4					
· · · · · · · · · · · · · · · · · · ·	g Gear Bending Centre N Cracks Crimp/K Cuffs Crushing Heat Tre Inspection Marks/C	Date: Date:	Date Step Qty Date Step Qty Gear Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube	Date: Date Step Qty Desc Date Step Qty Gear Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence	WORK ORDER NON Date: DISPOSITION Rework Scrap Use-as-is Suspected Unapproved Date Step Qty Description of work order update or non-conformance General Bending Bend Centre Not Concentric Cracks Broken/Damage/Defect Broken/Damage/Defect Crimp/Kink/Ripple/Wave Cuffs Contamination Countersink Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence Finish	WORK ORDER NON-CO	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence Finish DISPOSITION Rework Scrap Use-as-is Scrap Use-as-is Suspected Unapproved Initial Chief Eng Therm Scrap Suspected Unapproved Initial Chief Eng	WORK ORDER NON-CONFORMANCE / UP Date: DISPOSITION Rework Scrap Use-as-is Suspected Unapproved Date Date Step Oty Or non-conformance General Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Heat Treat Inspection Strip in Tube Drawing Marks/Chatter Turning Sequence DISPOSITION Rework Skid-tube Machining Thermoforming Large Fab Actic Chief Eng Descrip FAULT CATEGORY Skid-tube Machining Thermoforming Large Fab Machining Thermoforming Chermoforming Bend General Bend Grain Grain Hardware Inspection Incomplete/Unq Misaligned/off center Mislabeled Misread Off-set Out of Calibration Off-set Turning Sequence Finish Out of Calibration	Date: DISPOSITION Rework Skid-tube Crosstube Machining Small Fab Thermoforming Large Fab Composite	Date Disposition Rework Scrap Use-as-is Suspected Unapproved Use-as-is Date Step Qty Description of work order update Initial Action Date Date Chief Eng Description Date Date	Date: DISPOSITION Skid-tube Crosstube Machining Small Fab Prod. Eng. Coor.

Status

June-24-13 1:55:02 PM

Work Order ID:

103409

Parent Item:

D2933-2

Parent Item Name:

206 Saddle Right

Start Date: 6/24/13

Required Date: 7/12/13

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP: B00.06.26Ncw DWG rev (mpp 2069)EC

	IPP Rev:C As per l	Rev C 07-03-	I9 JUM									<u></u> _	
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary . Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	

D6101-001 100 Each 44.0000 No Manufactured 1 6 Saddle Billet

Location	Loc Oty	Loc Code	
MAT042	44		
97239	27		
98456	17		
			6

103637

DQA:		Date:											,	~ ΔΔΩΤ
QA Closed:		Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UF		Wor	k Order uş	odate only		AEROSPACE
Work Order					DISPOSITION	ì			AGAINST I		•		ļ !	
Work Order:					Dawa ak [i		Child Author	C	\neg				e
Part No.	_				Rework Scrap			Skid-tube Machining	Crosstube Small Fab	\dashv	Pro	Water Jet d. Eng. Coor.		Engineering Quality
	` 				Use-as-is			noforming	Finishing			re/Packaging	-	Other
NCR No.					Suspected Unapproved			Large Fab	Composite		1100,0101	Supplier		
	1 -							· · ·				<u> </u>		
Root	l _	_		Desci	ription of work order update	ı	Initial	Acti			Sign &		į	
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descri	iption		Date	Verification	n	QC Inspector
Design	4													
Doc/Data	4													• !
Equip/Tooling	1													
Handling/Pre														
Material	_		:			1								
Operator	_										•			
Offset/Setup						ŀ								
Process	_													
Supplier	_													
Training														
Transport]													
Unapproved														
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Landing	Gear				General					•				
	Bending				Bend .		Folio/P	rogram		C	Outside Dime	ensions		Pressure/Forced
	Centre No	ot Concer	ntric		BOM/Route		Grain		ſ	С	ver/Under	tolerance		Set-up
	Cracks				Broken/Damage/Defect		Hardwa	re	Ī	Р	art Incorrec	ct		Temperature/Cure
	Crimp/Kir	k/Ripple,	/Wave		Burrs		Inspecti	on Incomplete/Un	qualified	P	art Lost/Mi	ssing		Weld
	Cuffs				Contamination		Instruct	ions Incomplete/U	nclear	P	art Moved			Wrong Stock Pulled
	Crushing				Countersink		Misalig	ned/off center		ΠP	ositioned W	Vrong		
	Heat Trea	t			Cut Too Short		Mislabe		<u> </u>	_	ower Loss/S	- 1		Other
	Inspection	Strip in	Tube		Drawing		Misread	i	_			,		
	Marks/Ch	atter			Drill Holes		Off-set			_				
	Turning So	equence			Finish		1	Calibration		_				
	Wave/Tw	ist in Tub	e		Fit/Function		Out of S	Sequence		_				

DART AEROSPACE LTD	Work Order:	103409
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Re	corded Actu	ıal Dimensi	ons		-
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
А	0.100	0.140		-126	0126	.176	2127		
В	0.100	0.140		127	.127	.127	.125		
С	0.100	0.140		a 120	"122	.122	121		
D	0.210	0.230		215	:218	, 218	2220		
E	1.245	1.255		1.249	1.249	1.249	1.249		
F	1.245	1.255		1.249	1.249	1.249	1.249		
G H	. 2.495	2.505		2.498	2.498	2.498	2.498		
14	0.510	0.515		c512	.512	.512	.512		
1	1.572	1.582		1.577	1.576	1.576	1.575		•
J	2.495	2.505		2 498	2.498	2.447	2.497		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.314	1314	2314	.314		
М	0.235	0.240		2375	237	. 738	738		
N	0.100	0.140		109	2/18	.238 .118	119		
0	0.540	0.560		-545	.546	.546	\$540		
P	0.490	0.510		6495	.498	,497	<u>.497</u>		
Q	3.715	3.725		3 7 7	3.717	3.718	3.718		
R	2.470	2.510		2.490	2.490	2.490	2490		
S	0.240	0.270	70.	247	,250	250	251		
T	0.100	0.180		e130	.135	135	135	_	
Ü	1.625	1.635		1.428	1.629	1629	10629		
V	1.362	1.372		1.365	1.365	.366	1.366		
W	0.316	0.321	1	,316	.3((e	·31(0	316		
X	1.125	1.145		1.1327	1.1316	16/324	1.133		
Ŷ	1.565	1.585	DT2005-MB	1.570	1.570	1.5714	1,572		
Z	0.178	0.198		0188	188	188	188	_	
ΑĀ	0.170	0.130	-	0100	r (30	-170	6100		
AB									
AC								-	
AD									
AE								-+	
AF	tw	· · · · · · · · · · · · · · · · · · ·	-				·· ··		
AG	- "							-	• • • • • • • • • • • • • • • • • • • •
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ΔП		ept/Reje						-	

	D42.
Measured by:	Audited by 44
Date: 13-08-20	Date: 3/68/22

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	- 1
С	07.03.21	Revised per drawing revision C	KJ/JLM	911

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DART AEROSPACE LTD	Work Order:	103409
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C		Page 1 of 1

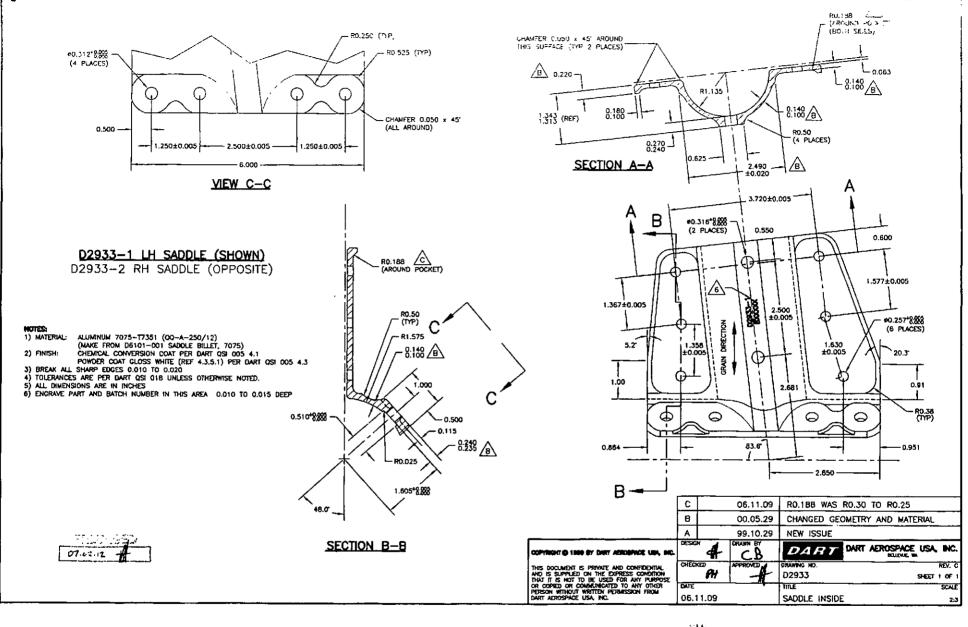
Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

			, ,	Re	corded Actu	ual Dimensio	ons		
Dim	Min	Max	Go/No Go Gauge	5%	63	159	45	Ву	Date
· A	0.100	0.140		6127	.124		-		
В	0.100	0.140		.125	.124				<u> </u>
С	0.100	0.140		121	1210				
D	0.210	0.230	<u> </u>	0218	0218				
E;	1.245	1.255		1.249	1.249				
F	1.245	1.255		1.249	1.249	-			
· (; —	2.495	2.505		2.498	2.498				
	0.510	0.515		4517	,512 1,570				
	1.572	1.582		1.577	1.5 Hz		-		
	2.495	2.505		2.497	2.498				
K	0.257	0.262		259	.259				
	0.312	0.317		.314	.314			T	
М	0.235	0.240		a 2375	2375				
N	0.100	0.140		0118	.546				
0	0.540	0.560		6545	546				
Р	0.490	0.510		2449	ृ प्रने				
Q	3.715	3.725		3.718	3.718				
R	2.470	2.510		2.490	2490			 	-
S	0.240	0.270		25	.251			 	
Т	0.100	0.180		.135	.135	 		† †	
U	1.625	1.635		1.629	10630				
·V	1.362	1.372		1.366	1.367				
W	0.316	0.321		.316	. 314				
X	1.125	1.145		1.1332	1.1325	1			
Y	1.565	1.585	D332051.WB	1.5722	1.57/5				
Z	0.178	0.198		.188	.188				
ĀĀ				· · · · · · · · · · · · · · · · · · ·					
AB						i i		 	•
AC				1				1	
AD							1	 	
AE		-				 		 	
AF								† — †	
AG				 				 	
AH		-					_		
	Acc	ept/Reje	ct .			 -	- CAS	 -	
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			~~)	
Measured by:		Audited by	S_89	
Date:	13-08-20	Date:	13/08/22	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
В	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	21
C	07.03.21	Revised per drawing revision C	KJ/JLM o	

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